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D5634-041BENT
Job Sheet 197993



Part No: D5634-041BENT

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly, Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/19/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/9/19

Description:

Type: Stock

Note: DWG D5634 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	8/9/19	8/9/19	0.50	0.22	Skidtubes - Bend		<i>MBR</i>
120	QC 5	1 pcs	8/9/19	8/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	8/9/19	8/9/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S203752



Part: D5634-041BENT

Job No: 197993

Serial No/Batch: S203752

Revision: A

Inspector:

Exp Date:

Instructions:

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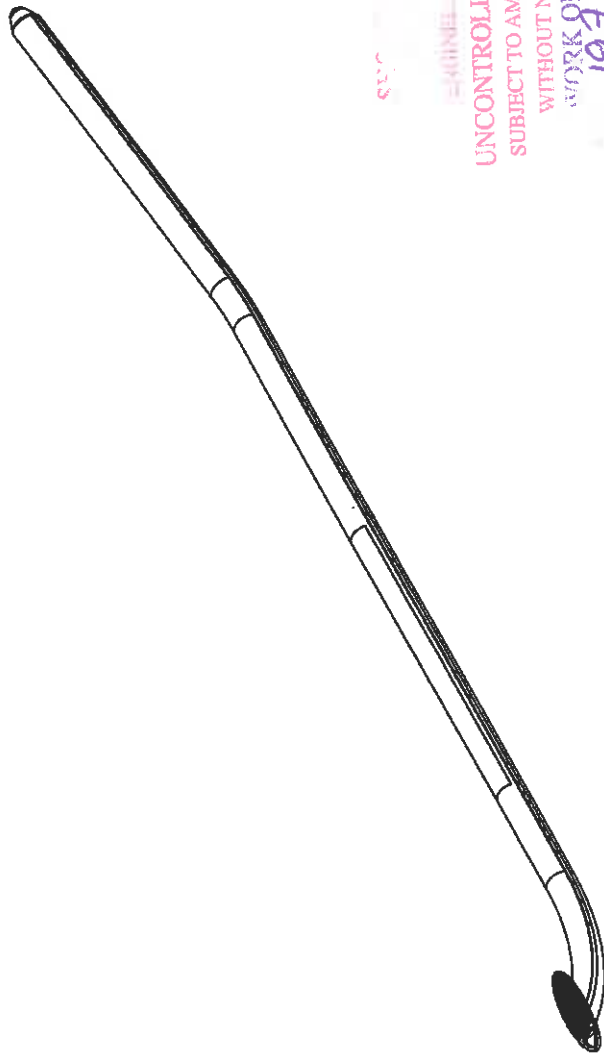
Date: 08/08/19

Plex 7/19/19 11:36 AM Dart.lajeunesse.marie

					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	BE
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	BE
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAG
140	QC 21 - SA	1 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21	21 SEP 05 2019
					QC 21 - SA - 70	9:59
Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog D5634 Descriptions: FWD and foil as per dwg D5634, cut fwd end of tube with saw table setup D5634 . 2- Test fit FWD cap. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D2600-1-190	Extrusion Round 3" 206	1 pcs (1 ea)	110-Skidtubes - Bend - 1	S113022		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
110-Skidtubes - Bend - 1	D2600-1-190	1	26	0		
Part Specifications						
Specifications could not be found.						

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QTY -041	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2846	AFT CAP
7	D3275-1	SPACER
23	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5634-1	FLOAT SKIDTUBE
1	D5636-041	FLOAT WEB ASSEMBLY
2	MS24683-C272	SCREW, CSK 100°



D5634-041 FLOAT SKIDTUBE ASSEMBLY

UNCONTROLLED
SUBJECT TO AME
WITHOUT NOTICE
WORK ORDER
19753415
190719

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2, 1.3 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOE RANGES: PER DART QSI 014 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 21.03 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX 241/281 OR PROSEAL P/S 88071422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX 241/281 OR PROSEAL P/S 88071422 OR MIL-S-8802 CLASS B2 SEALANT
 - 10) LOCATE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
 - 11) DAMAGE TOLERANCE ON BENDS:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
WELDING PER QSI 004
 - 12) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED
2019 JUN 27
EAW R-746

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN	ZF	DART AEROSPACE LTD			18.04.24
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MM	DRAWING NO.			
MFG. APPR.	DD	D5634			REV. A
APPROVED	NO	TITLE			SHEET 1 OF 4
DE APPR.	CP	FLOAT SKIDTUBE ASSEMBLY			SCALE
DATE	18.04.24				NTS

Date:



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS						Route update only		
Date :		Sequence #:			QTY Affected :			MRB (QSI042)					
Description Work Order Deviation		Disposition											
													Completed By
													Lead hand / Supervisor
													QC / QA Coordinator
Root Cause		FAULT CATEGORY											
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong					
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance					
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing					
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish					
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing					
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread					
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up							
Human Factors		Other/Details:											